



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-2RLC
Job Sheet 167727



Part No: D2933-2RLC

Job Qty: 2 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/6/17

Job Tracking No:

Due Date: 12/8/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Machining		SBL 04/12/17
100	CNC Vertical Machining	2 pcs	12/7/17	12/7/17	0.14	2.35	HAAS 1		FK 17-11-28 SBL 04/12/17
110	Mill Conv	2 pcs	12/7/17	12/7/17	0.00	2.35	Mill Conv 1		FK 17-11-28 SBL 04/12/17
120	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC1		FK 17-11-28 SBL 04/12/17
130	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC8		2017-12-12 13
140	HandFinish	2 pcs	12/7/17	12/7/17	0.00	0.11	HandFinish1		2017-12-12 13
150	SprayPaint	2 pcs	12/8/17	12/8/17	0.00	0.21	Spray Paint		AS JAN 05 2018
160	QC	2 pcs	12/8/17	12/8/17	0.00	0.00	QC14		PD 11 JAN 10 2018
170	Packaging	2 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3	57405	AT 10-11-89
180	QC21-SA	2 Ea	12/8/17	12/8/17	0.00	0.00	QC21		

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - (Boeing primer and same paint as float skid tubes).

Prime 138408
Paint 138669

DAS
21
2018

JAN 1 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	2	29	0	0

Part Specifications

Specifications could not be found.

Plex 11/6/17 10:31 AM dart.Michaud-Febrille.Victoria

DART
AEROSPACE
S014306

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Saddle RH In, 206

PART NO: D2933-2RLC
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 11/27/17

Job No: 167727

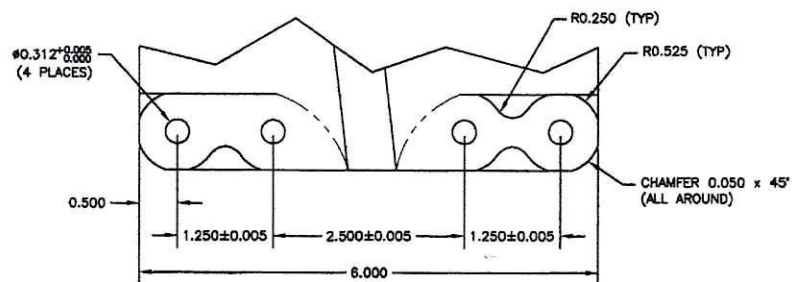
DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.122				
B	0.100	0.140		.121	.121				
C	0.100	0.140		.113	.114				
D	0.210	0.230		.221	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.257	.257				
L	0.312	0.317		.312	.313				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.120	.120				
O	0.540	0.560		.500	.499				
P	0.490	0.510		.495	.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.495	2.497				
S	0.240	0.270		.245	.242				
T	0.100	0.180		.140	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.125	1.145		1.135	1.135				
Y	1.565	1.585	DT8695 A/B	1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>SBL</u>	Audited by: <u>17/12/03</u>
Date: <u>04/12/17</u> / <u>17-11-28</u>	Date: <u>17/12/03</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

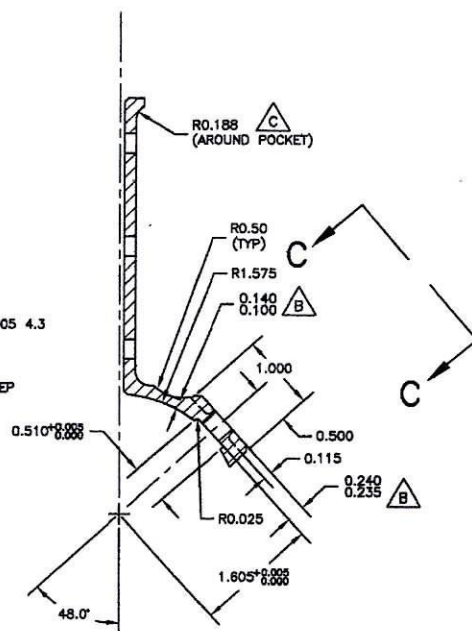


VIEW C-C

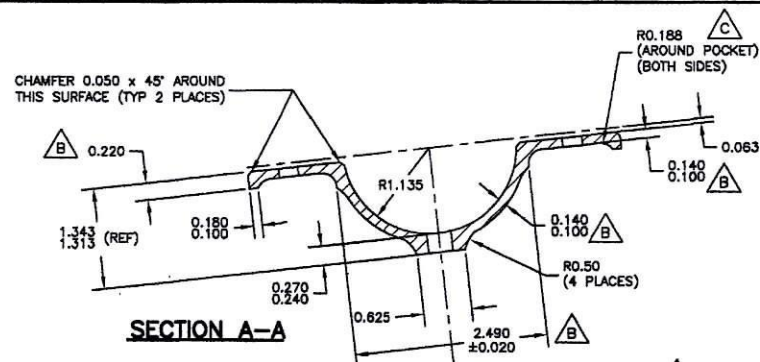
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

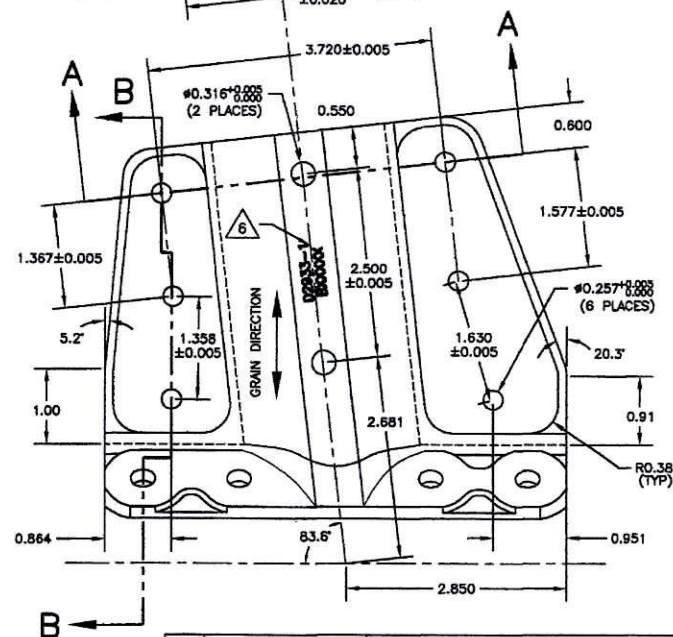
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC.
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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07.02.12